Work	Ω	rder	ID	66547
VVUIN	V	luci	11/	しいしょうサ /

Tuesday, February 22, 2011 9:12:38 AM



Page 1

Item ID:

D3278-3

Accept



Setup Start

Stop



Revision ID:

Item Name: Spacer

Required Date: 2/25/2011

2/22/2011

Start Qty: 40.00 Req'd Qty: 40.00

Cust Item ID: Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date: 1/-02-22 Tooling:

Date:

SPC (Y/N):

Date:

Run

Stop

Start



Sequence ID/ Work Center ID

Operation Description

Revision Nbr

Set Up/ **Run Hours** **Tool ID**

Tool # Plan

Date:

Accept **Qty**

Code

Reject Qty

Reject Insp. Number Stamp

Draw Nbr D3278

Rev C

QC:

100

Waterjet

FLOW CNC Waterjet

DELRIN 1125 FLOW WATER JET

Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

Memo

1-Cut as per Dwg D3278

□Dwg Rev:

0.00

C □Prog Rev: C □2-

MM vog pelles BII-2-28

110

Memo

0.00

0.00

0.00

1311-2-08

Quality Control

120

Quality Control

Memo

QC8- Inspect parts - second check

Dart Aerospace

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W/O:			W	ORK ORDER CHANG	GES			_		
DATE	STEP	PRC	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							 			
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Part No		PAR #:	Fault Cate	egory:	NCF	R: Yes	No DQ	A :	Date:	
		esolution:								
NCR:			WORK ORE	ER NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC			tion B	0, 0	Verific	ation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng			Sign & Section C Date		on C	Chief Eng	QC Inspector
		•								-

Work Order ID 66547

Tuesday, February 22, 2011 9:12:38 AM



Page 2

Item ID:

D3278-3

Accept

Setup Start

Stop



Revision ID:

Item Name: Spacer

Required Date: 2/25/2011

2/22/2011

Start Qty: 40.00 Req'd Qty: 40.00

Cust Item ID: Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start

Run



QC:

Date:

SPC (Y/N):

Date:

Stop

Reject

Qty



Sequence ID/ **Work Center ID**

130

Small Fab

Operation Description

Set Up/ **Run Hours**

0.00

0.00

1-C'sink as per dwg D3278□2-Deburr

Tool ID

Tool # Plan Code

Accept Qty

Reject Number Insp. Stamp

Memo Small Fab

Small Fab

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

150

Packaging Packaging

Memo

Memo

Identify as per dwg & Stock Location MAL Fall

0.00

Dart	Aerospace	Ltd

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W/O:			WO	RK ORDER CHANG	GES				
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	Sign 8	& Sec	ication tion C	Approval Chief Eng	Approval QC inspector
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Work Order ID 66547

Page 3

Tuesday, February 22, 2011 9:12:38 AM

Item ID:

D3278-3

Revision ID:

Item Name: Spacer

Start Date:

2/22/2011

Start Qty: 40.00 Required Date: 2/25/2011

Req'd Qty: 40.00

Operation

Description



Accept



Cust Item ID:

Customer:

Setup Start

Stop



Reference:

Approvals:

Process Plan:

QC:

Date:_____

Date:

Tooling:

SPC (Y/N):

Set Up/

Tool ID

Date:

Tool # Plan

Code

Date:

Reject

Stop



Sequence ID/

Work Center ID

160

Quality Control

Memo

QC21- Final Inspection - Work Order Release

Run Hours

0.00

0.00

Run

Accept

Qty

Start

Insp.

Qty Number Stamp

Reject

n/03/04 /2 U (1.03-02

70 L 10

Dart Aerospace	Ltd
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W/O:	/O:		WORK ORDER CHANGES								
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	es No	DQA:	Date: _			
	PARE STEP PROCEDURE CHANGE Part No: PAR #: Fault Category: Resolution: Disposition: ICR: WORK ORDER NON-CONFOR	n:	QA: N/C								
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DATE	CTED	Description of NC					erification	Approval	Approval		
DATE	SIEP	Section A		Action Description Chief Eng	Sig Da	n& Section C		Chief Eng	QC Inspector		
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	1										

Picklist Print

Tuesday, February 22, 2011 9:12:44 AM

Work Order ID: 66547

Parent Item:

D3278-3

Parent Item Name: Spacer



Start Date: 2/22/2011

Required Date: 2/25/2011

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP . A□ 04.04.19□New issue□KJ/JLM□

IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Prin Item Loca	•	Route n Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINS0.125		Purchased	No		110	sf	0.0000	0.0344	1.448421	7.		
									1/2	1 >- 2	10	

Black Delrin Sheet .125

116779

(5)

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES	· · · · · ·				· · · · · · · · · · · · · · · · · · ·
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Part No	:	PAR #:	Fault Ca	tegory:	NCR:	Yes N	lo DQA		Date:	
	R	esolution:	Disposit	ion:	QA: 1	VC Clo	sed:		Date:	
NCR:			WORK OR	DER NON-CONFORM	ANCE	(NCR))			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Description	tion B	Sign &	Verifica Section		Approval Chief Eng	Approval QC Inspector
		Section A	Chief Eng	Chief Eng		Date	Section		Offier Eng	QC ITISPECTOR
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DART AEROSPACE LTD	Work Order:	46547
Description: Spacer	Part Number:	D3278-3
Inspection Dwg: D3278 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.98	+/-0.030	1.988	×		V 1802	
1.98	+/-0.030	1.990	7		V	
1.480	+/-0.005	1.478	⊳		V	
0.250	+/-0.010	, 555	16		V	
1.480	+/-0.005	1.480	صر		V	
0.250	+/-0.010	6950	7		V	
Ø0.098	+0.005/-0.000	,094	صر		V	
R0.13	+/-0.030	,13	>		Ř.G.	
0.125	+/-0.010	-136	y	3	V .	
					·	

Measured by:	1B	Audited by:	9,	Prototype Approval:	N/A
Date:	11-2-28	Date:	4/02/7E	Date:	N/A

Date	Change	Revised by Approve	∌d_
04.04.19	New Issue P/O D3278-041	KJ/JLM	
06.03.09	Dwg Rev updated	KJ/JLM	
07.02.02	Dwg updated per JLM	KJ/JLM	
07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC X	
	04.04.19 06.03.09 07.02.02	04.04.19 New Issue P/O D3278-041 06.03.09 Dwg Rev updated 07.02.02 Dwg updated per JLM	04.04.19 New Issue P/O D3278-041 KJ/JLM 06.03.09 Dwg Rev updated KJ/JLM 07.02.02 Dwg updated per JLM KJ/JLM

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W/O:			W	ORK ORDER CHANG	SES					
DATE STEP P			OCEDURE CHANGE		E	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cat	tegory:	NCR:	Yes N	o DQ .	A :	_ Date: _	
	R	esolution:	Disposition:						Date:	
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DATE	STEP	Description of NC		Corrective Action Section B		Verif		ication Apr	Approval	Approval
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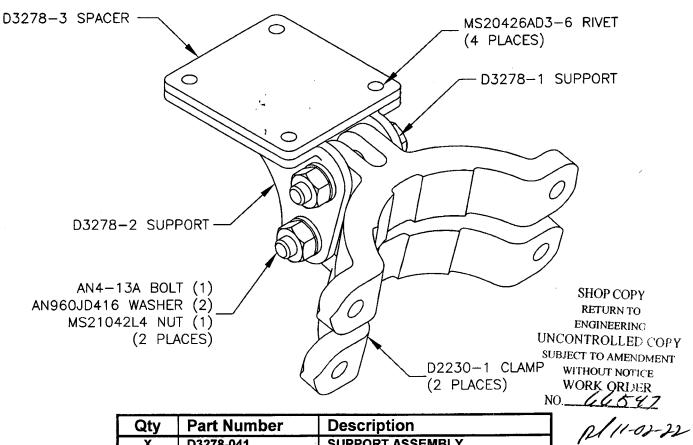
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CHEC	KED 6	APPROVED	DRAWING NO.	REV. C
	-A	#	D3278 SHEET	1 OF 3
DATE		, , , , , , ,	TITLE	SCALE
07.0	7.24	_	SUPPORT ASSEMBLY	NTS
Α		04.03.03	NEW ISSUE	
В		05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
С		07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description	
Х	D3278-041	SUPPORT ASSEMBLY	
2	D2230-1	CLAMP	
1	D3278-1	SUPPORT	
1	D3278-2	SUPPORT	
1	D3278-3	SPACER	
	"		
2	AN4-13A	BOLT	
4	AN960JD416	WASHER	
4	MS20426AD3-6	RIVET	
2	MS21042L4	NUT	

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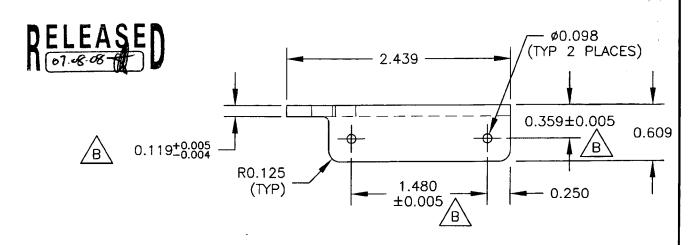
Dart Aerospace Ltd

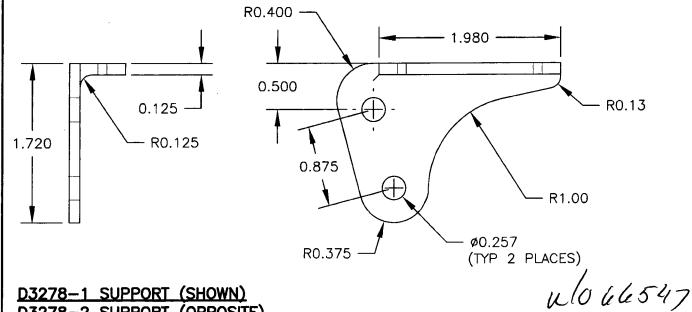
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1 4	-#	D3278	SHEET 2 OF 3
DATE		TITLE	SCALE
07.07.24		SUPPORT ASSEMBLY	1:1





D3278-1 SUPPORT (SHOWN) D3278-2 SUPPORT (OPPOSITE)

1) MACHINE PER DWG FILE "D3278-1.SLDPRT"

2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR

PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)

PER AMS-QQ-A-200/8 (OR AMS 4160)

(REF. DART SPEC. M6061T6B)

3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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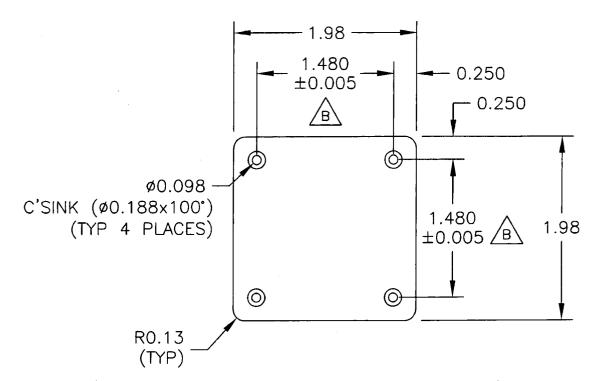
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DATE		TITLE	SCALE
07.07.24		SUPPORT ASSEMBLY	1:1





WO 46547

D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
 (REF. DART SPEC. M-DELRIN-B0.125×2.000) OR
 DELRIN II 150E OR ACETRON GP ACETAL
 (REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Part No	•	PAR #:	Fault Ca	tegory:	NCR: Yes No DQA: Date:				
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